

304 R 1.000"


Work Order ID 76238

76238

Page 1

Monday, November 07, 2011 2:46:17 PM

Item ID: D3503-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cup
 Start Date: 11/7/2011 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan:  Date: 11-07 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3503	Rev A								

100
 100
 Hardinge
 Hardinge CNC Lathe Small
 Operation Description: Hardinge CNC LATHE SMALL
 Memo: 1-TURN AS PER FOLIO FA635 & DWG D3503,
 FOLIO REV: AA
 DWG REV: A
 2-DEBURR AS REQUIRED
 Set Up/Run Hours: 0.00



10 0 11/12/23

110
 110
 QC
 Quality Control
 Operation Description: QC2- Inspect parts off machine FAI/FAIB
 Memo:
 Set Up/Run Hours: 0.00

10 0 11/12/23

120
 120
 QC
 Quality Control
 Operation Description: QC8- Inspect parts - second check
 Memo:
 Set Up/Run Hours: 0.00

A.A 11/12/23

10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11/2/29 (10)

CK 12/01/02

11-12-29
 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Monday, November 07, 2011 2:46:21 PM

Work Order ID: 76238

76238

Parent Item: D3503-1

D3503-1

Parent Item Name: Cup

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-05-04 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R1.000		Purchased	No			100	f	51.8250	0.065	0.684211			
------------	--	-----------	----	--	--	-----	---	---------	-------	----------	--	--	--

M304R1 000

304 round bar 1.00

**

0.583'

SL 11/12/23

Location

Loc Qty

Loc Code

MAT029

51.825

109508

12.5

109541

0.08

113457

39.245

0.583'

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

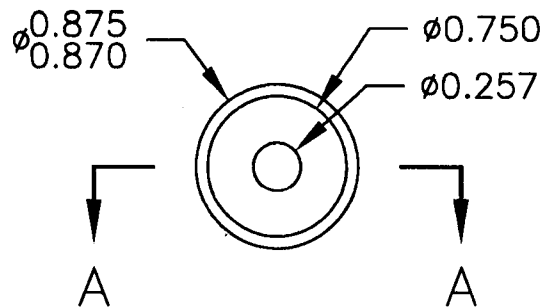
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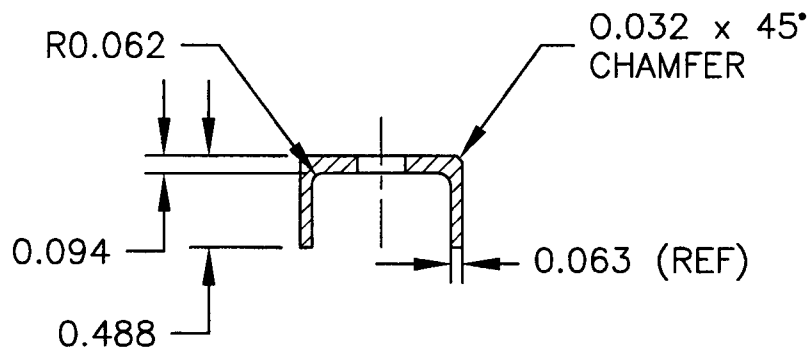
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3503	REV. A SHEET 1 OF 1
DATE 06.04.19		TITLE CUP	SCALE 1:1
A	06.04.19	NEW ISSUE	

RELEASED
06.04.25



D3503-1



SECTION A-A

D3503-1 CUP

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART MATERIAL SPEC M304RX.XXX)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14238

PH-11-07

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